

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-133 Date Opened: 01 August 2017 Title: FabricationAircraft OEM: Eurocopter Aircraft Model: AS350/355 Product Type: Cargo Basket & Lid Product Model: XL Quantity: 5/5**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

4 / 4
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
JC
N/A
N/A
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94011	1	Body	JC
94012	1	Lid	JC
70405	4	Lid Walkway	JC
84262	2	Basket Handle Prov.	JC
84263	0	Lid Handle Provisions	JC
94023	1	Attachment Hoop	JC
94030	1	Hoop	JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: D. Hammer / J. RekveSign: [Signature]SCA: AD01Date: 22-Sep-17

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: [Signature]SCA: AD02Date: 22-Sep-17

Work Order closed by:

Print: J. ClarkeSign: [Signature]SCA: AD02Date: 23-Oct-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

2017-133

(S) AS350 Ski
4jc.

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket ← *

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

DRM
(4) (5) AS350 Ski

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2017-133

Date Open: Aug 1, 2017

1. Rim Assembly – Basket Lid

- Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly

- Record welding rod PO on attached material list.

3. Inspection

- Rim for complete welds

4. Frame assembly – Lid

- General
 - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- Insert rim from step 2 into jig.
- Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- Drill vent holes into rim to vent cross members into rim.
- Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

5. Frame assembly – Lid with optional walkway modification

- Fit cross members to rim in accordance with step 4.
- Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- Drill vent holes into cross members at walkway stringers.
- Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

6. Weld frame assembly.

- Record welding rod PO on attached material list.
- Jigs must remain in place for as long as practical during welding.

7. Inspection

- Frame assembly for complete welds.

CARGO BASKET LID FABRICATION

Complete

(initial or SCA #)

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

AD 73-04 05 AD 73-04 05 AD 73-04 05 AD 73-04 05

N/A

9. Weld mesh to frame assembly per drawing.

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
 - $\frac{3}{4}$ " for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

AD 73-04 05 AD 73-04 05 AD 73-04 05 AD 73-04 05

N/A

10. Weld lid components.

- Handle brackets, locate in accordance with drawing.
 - Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

N/A

11. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - 3 places for lids under 76"
 - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

N/A

12. Final Inspection

To be completed by a different person than the previous steps.

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)
N/A

13. Powder Coating

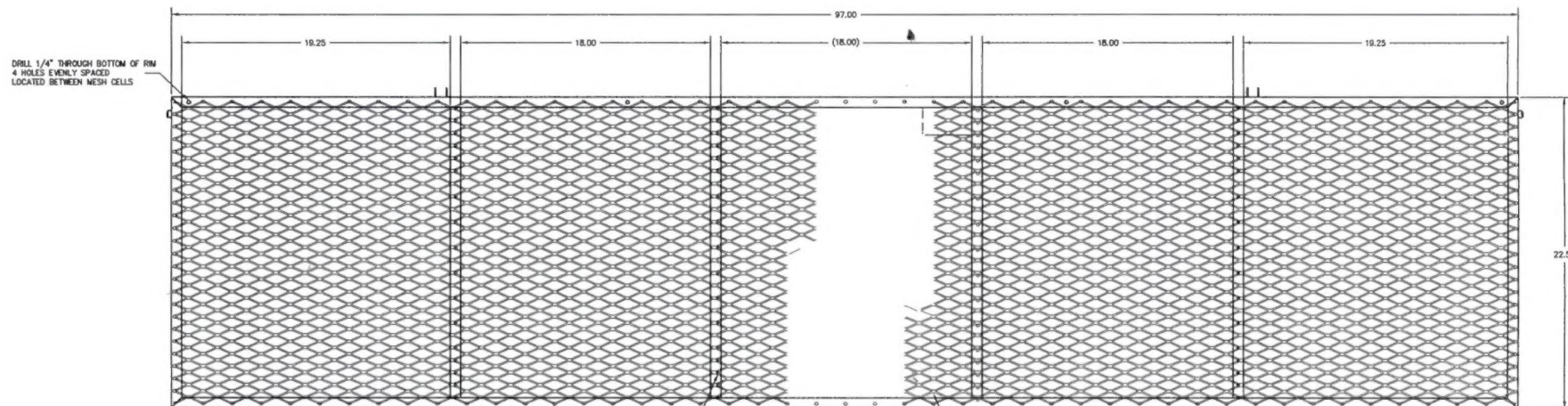
- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag lid assembly and place into stock in preparation for assembly.

<u>AD 73-04 02</u>	<u>AD 73-04 02</u>	<u>CMB</u>	<u>CMB</u>	<u>N/A</u>
		AD 73-04 02	AD 73-04 02	

2017-133

X(5) AS350 SH:

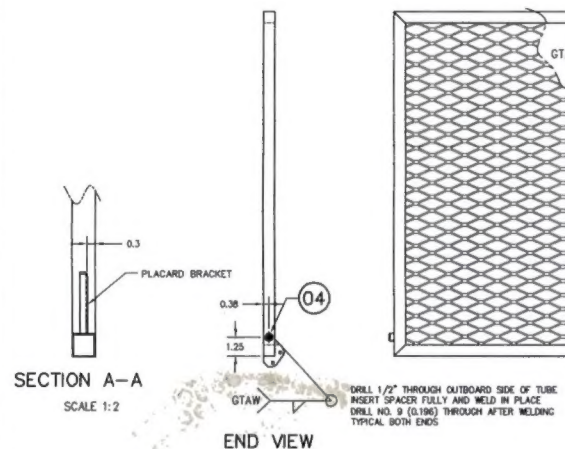
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; CHANGED 36273-01 TO 84263-01; ITEM #S ADDED	BJC	10/07/2014
	WELDING ROD UPDATED; # OF WELDS DOWN BRACE TUBES INCREASED		



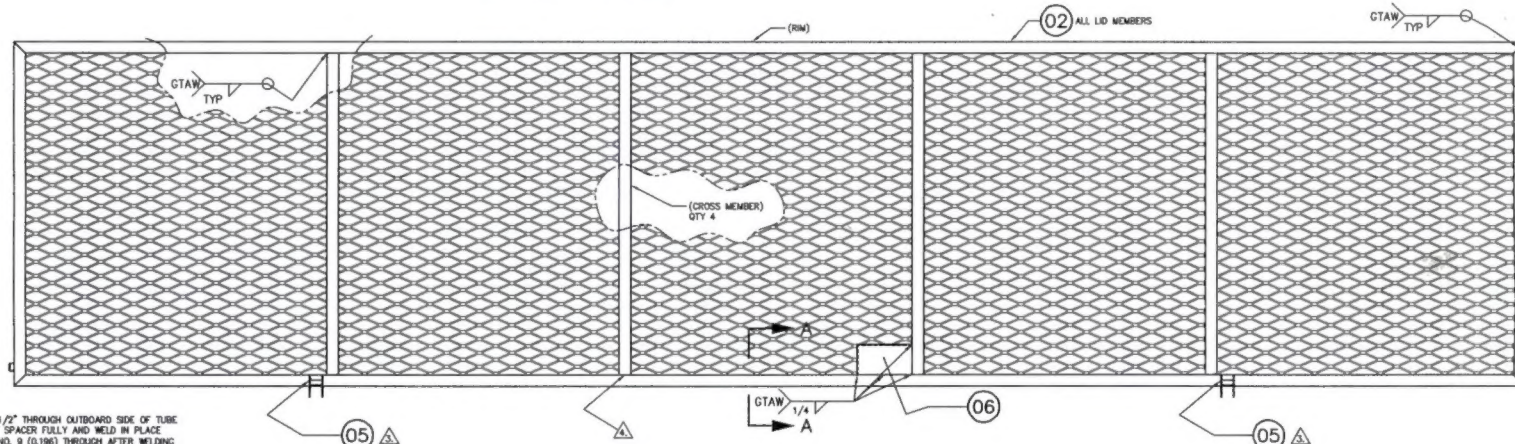
GTAW TYP
ATTACHMENT OF MESH TO RIM: WELD EACH INTERSECTION

GTAW TYP
ATTACHMENT OF MESH TO CROSS MEMBERS: WELD FIRST FIVE INTERSECTIONS THEN EVERY SECOND INTERSECTION. ADDITIONAL WELDS ARE PERMITTED AS REQUIRED.

BOTTOM VIEW (03) MESH



END VIEW



TOP VIEW

(01) LID ASSEMBLY

NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
- 4130 AND 1/8" STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
- INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263.
- DRILL #30 (0.125) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	36204-10	06	PLACARD BRACKET			
1	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
2	49216-01	04	SPACER			
A/R	3/4 - 16F	03	MESH	MILD STEEL	COMMERCIAL	
A/R		02	SQUARE TUBE	4130 STEEL COND. N	MIL-T-6736	0.75 X 0.035 SQR TUBE
	84012-01	01	LID ASSEMBLY			

LIST OF MATERIALS

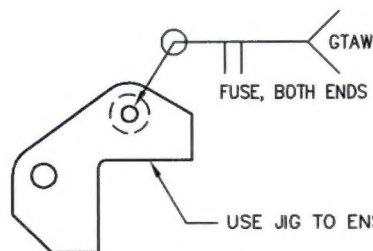
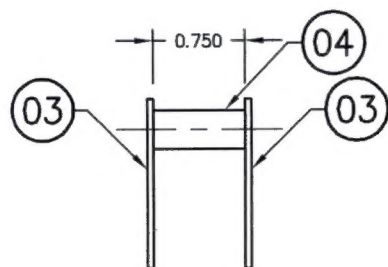
APPROVALS	DATE	AERO DESIGN LTD.	
DRAWN: R. RATHWELL	05 AUG 11	9008A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G5 TEL: 854-481-9578 www.aerodesign.ca	
CHECKED: E. BURGON		EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET LID ASSEMBLY (EXTRA LARGE)	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		SCALE 1: 4	REV.
SHEET 1 OF 1		DWG. SIZE A1	DWG. NO. 94012

2017-133

AS350 SKI X (5)

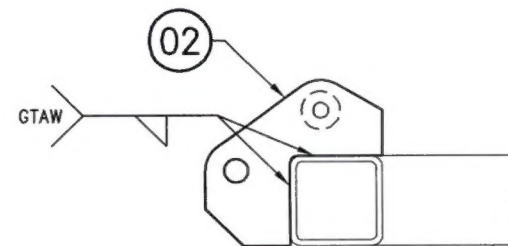
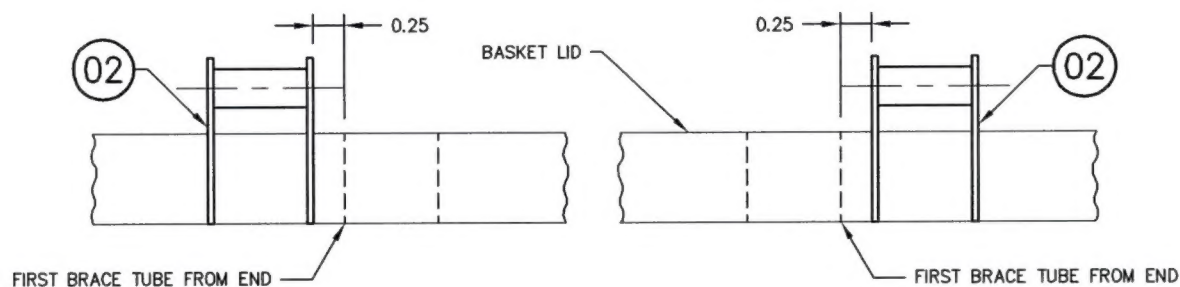
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 84262 REV. 1	BJC	14/02/2014



USE JIG TO ENSURE BRACKETS ARE ALIGNED

02 HANDLE BRACKET ASSEMBLY



01 LID HANDLE PROVISIONS ASSEMBLY

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER308L OR EQUIVALENT.

1		36275-02	04	SUPPORT
2		36273-01	03	LID BRACKET
	2	84263-02	02	HANDLE BRACKET ASSEMBLY
		84263-01	01	LID HANDLE PROVISIONS ASSY
02	01	PART NO.	ITEM	DESCRIPTION
QTY	QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	14 FEB 2014
CHECKED: JASON REKVE	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



AERO DESIGN LTD.

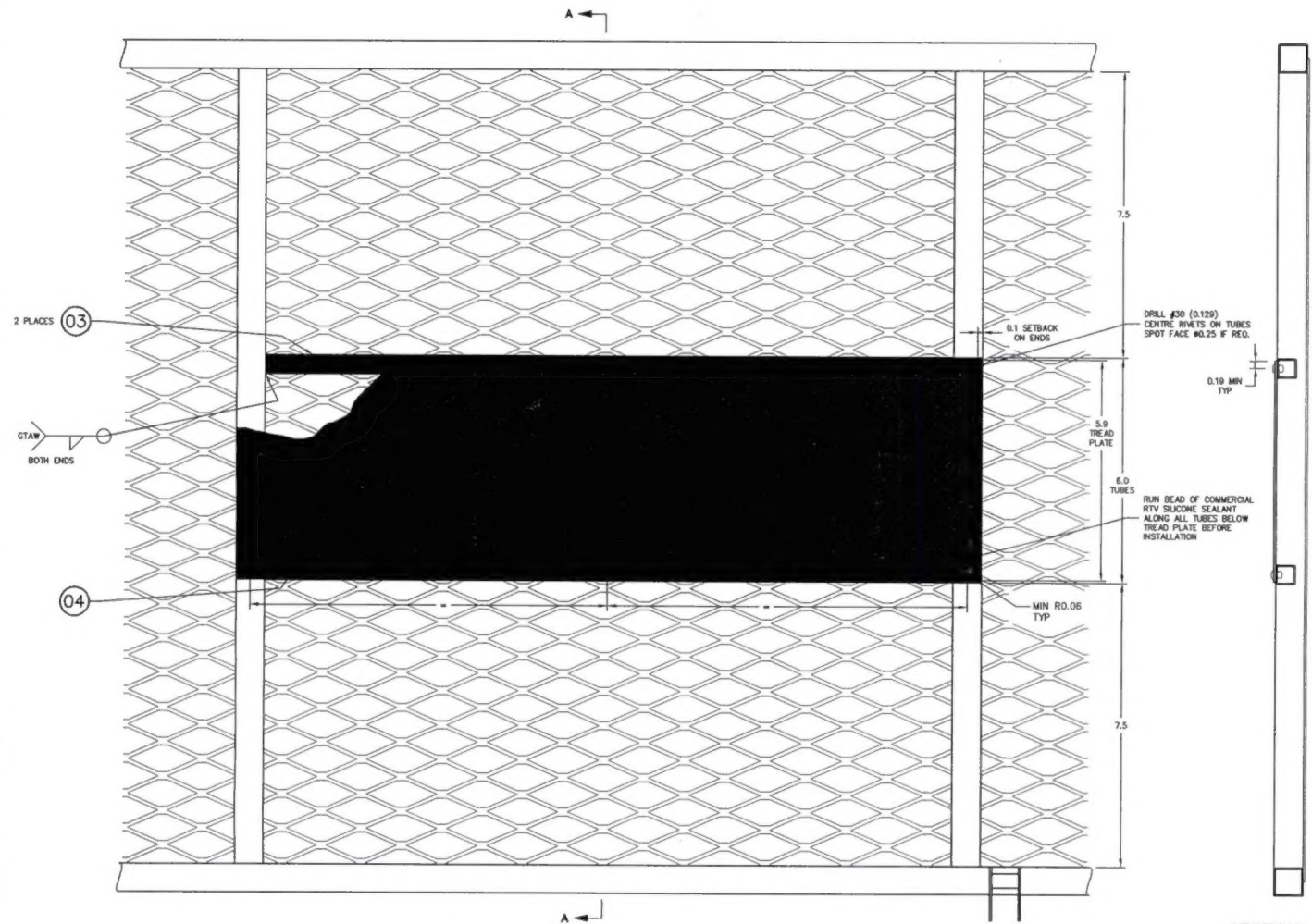
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.2376 www.aerodesign.ca

HELICOPTER CARGO BASKET
LID HANDLE PROVISIONS ASSEMBLY

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84263	0

2017-133

AS350 Ski X (5)



(01) BASKET LID ASSEMBLY

SECTION A-A

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014

- NOTES:
1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
 2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
 3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
 7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE	
2	70405-03	03 TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						

AERO DESIGN LTD.
8888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G5
TEL: 864.483.8976
www.aerodesign.ca

APPROVALS
DRAWN: JEFF CLARKE 21 SEPT 2006
CHECKED: E. BURGOIN
DATE: 21 SEPT 2006

BASIC CODES:
BJ = MS20470AD
BG = MS20426AD
ARN = CR3213
ARM = CR3212

DASH NO. FOR DIAMETER
H=MFD, HEAD NEAR SIDE
F=MFD, HEAD FAR SIDE
D=DIMPLE
DIGIT # OF SHEETS TO BE DIMPLED

DASH NO. FOR LENGTH
+ C INSTALL NEW RIVET
+ R REMOVE/REPLACE RIVET
- E EXISTING RIVET

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:
DECIMALS X.XXX ±0.010
X.XX ±0.03
X.X ±0.1
ANGLES ±1/2"

CARGO BASKET LID STEP MODIFICATION

SCALE	1 : 1.5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	70405	4	

Work Order: 2017-133Date Opened: Aug 1, 2017Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>5</u>	94012	94012-01	Lid Assembly		
Step 1				Rim Assembly		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17055</u>
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17055</u>
Step 2				Weld Rim Assembly		
	. A/R			Welding Rod	ER70S-2 TIG Rod	<u>14033/17037</u>
Step 3				Inspection - Rim	None	
Step 4				Frame Assembly		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17004</u>
Step 5		70405		Option: Frame Assembly - with walkway		
	. 10		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>17038</u>
Step 6				Weld Frame Assembly		
	. A/R			Welding Rod	ER70S-2 TIG Rod	<u>14033/17037</u>
Step 7				Inspection - Frame Assembly	None	
Step 8				Mesh Assembly		
	. 1		--	Mesh (lid - 96" x 22")	3/4-16F Expanded Mild Steel sheet	<u>17025</u>
Step 9				Weld Mesh		
	. A/R			Welding Rod	ER70S-6 MIG Wire	<u>16078</u>

Work Order: 2017-133Date Opened: Aug 1, 2017Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		2016-147
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R			Welding Rod	ER308L TIG Rod	17066
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	2015-84
	. A/R			Welding Rod	ER308L TIG Rod	17066
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	2016-119
	. A/R			Welding Rod	ER70S-2 TIG Rod	14033
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				Powder Coating		17085 (2) 17088 (2)

CARGO BASKET HOOP FABRICATION - 94023

General

These instructions apply to cargo basket attachment hoop 94023-01. Refer to the following drawings, at the current revision, for dimensions and details:

94023, Revision 0 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly


Work Order: 2017-133

Date Open: Aug 1, 2017

Complete
(initial or SCA #)

X(10)

1. ½ Hoop Fabrication – ½" hoop ~~X22~~

- Cut ½" x 0.035 material to 23.0", square ends. → 
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- Remove writing on tubes with acetone and scotch bright.
- On the hoop bending fixture, set the following stops:
 - Upper tube stop: ??
 - Lower bend stop: 12mm
- Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- Slide shim all the way forward on bender to secure tube in die
- Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- Check for:
 - hoop height: 18" (Outside to outside)
 - adjust upper stop for height if required

dk dk dk dk dk x 10

2. ½ Hoop Machining – ½" hoop – Handle Provisions 84262-01

- Start with ½" half hoop from step 1.
- Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - locate 0.23" from edge (within tolerance specified on drawing).
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

JC x10

3. ½ Hoop Fabrication – 1" hoop $\times 2$ 33.5

- Cut 1" x 0.065 material to 33.25", on end 60 degrees, one end @ 16 degrees. 33.25" distance is short edge of 16 deg to long edge of 60 deg. AKAKAKAKAK x 10 dk
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- Remove writing on tubes with acetone and scotch bright.
- Mark tube at 15 11/16" from long edge of 16 degree end. 143/16
- Set lower stop to 101 degrees
- Slide stock tube through bending die up to mark. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains at mark.
- Slide shim all the way forward on bender to secure tube in die
- Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- Check tube bend for angle using hoop jig. Adjust stops if required.
- Check for:
 - hoop height from jig
 - adjust mark for height if required
 - bottom length
- De-burr cut end using a sanding disc on a die-grinder or disc sander.

4. ½ Hoop Machining – 1" hoop DA DA DA DA DA JC x10

- Start with 1" ½ hoop as stock.
- Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.75" and set X 0. Shift Y -0.5". Set stop against end of tube.
- Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Set tube in vise with 60 degree end on right.
- Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

5. Joint Preparation AK x10

- Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.
- Insert one 94023-07 lug (flat end) at top and 94023-05 lug (angled end) at bottom into holes in 1" hoop. Seat top lug flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop. Mark 94023-07 lug and trim or grind to fit.

6. Welding – Lugs X(10)

CARGO BASKET HOOP FABRICATION - 94023

Complete
(initial or SCA #)

- a. Insert one 94023-07 lug (flat end) at top and 94023-05 lug (angled end) at bottom into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop.
- b. TIG weld all around both sides of lugs. 2 places. Grind angled lug into radius of hoop before welding.
- c. Record lug and welding rod PO/WO on attached material list.

X(10)

AD
7-3-04
08

7. Welding – Handle Bushings – 84262-01

- a. Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

X(10)

AD
7-3-04
08

8. Welding – Hoop Assembly

- a. Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around ½" hoop in slot.
- d. Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

9. Finishing and Inspection

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

OK x10



Aero Design Ltd.

AMF 73-04

9888 A Malaspina Rd.

Powell River, BC

Canada

V8A 0G3

Complete Fabrication Instructions

This sheet is designed to assist in the fabrication of Aero Design products in accordance with the company Manufacturing Policy Manual, the Canadian Aviation Regulations and other applicable technical documentation.

The reference column of the following table is for reference unless a specific instruction is called out.

The initial columns serve one column per component fabricated on the applicable work order.

Nomenclature: AS350 Quick Release Ski Basket Hoop Work Order #: 2017-133
Number of Units: 20-16-128

Model	Requirements	Reference	Initial			
AS350	Review LOEP to ensure most current technical specifications	N/A	<i>OK</i>	<i>x10</i>		<i>jc x2</i>
AS350	Cut a piece of material to 53 1/8" <i>x4</i>	N/A	<i>OK</i>	<i>x10</i>		<i>jc x2</i>
AS350	Cut one end at 90 degrees and the opposite end at 16 degrees.	N/A	<i>OK</i>	<i>x10</i>		<i>jc x2</i>
AS350	At the 90 degree end measure 20 5/16 and mark, then 32 1/8 and mark.	N/A	<i>OK</i>	<i>x10</i>		<i>jc x2</i>
AS350	Set tube at 20 5/16 mark, bend at that mark, set stop at 105 deg.		<i>OK</i>	<i>x10</i>		<i>jc x2</i>
AS350	Flip tube, set at next mark, bend at that mark, set stop at 86 deg.	N/A	<i>OK</i>	<i>x10</i>		<i>jc x2</i>

Post Fabrication Inspection

Inspect components to ensure conformity to the applicable design data.

Signature: *[Signature]*

Licence Number or SCA: _____

Date: _____

1/2 INCH TUBE (REF)

2.00

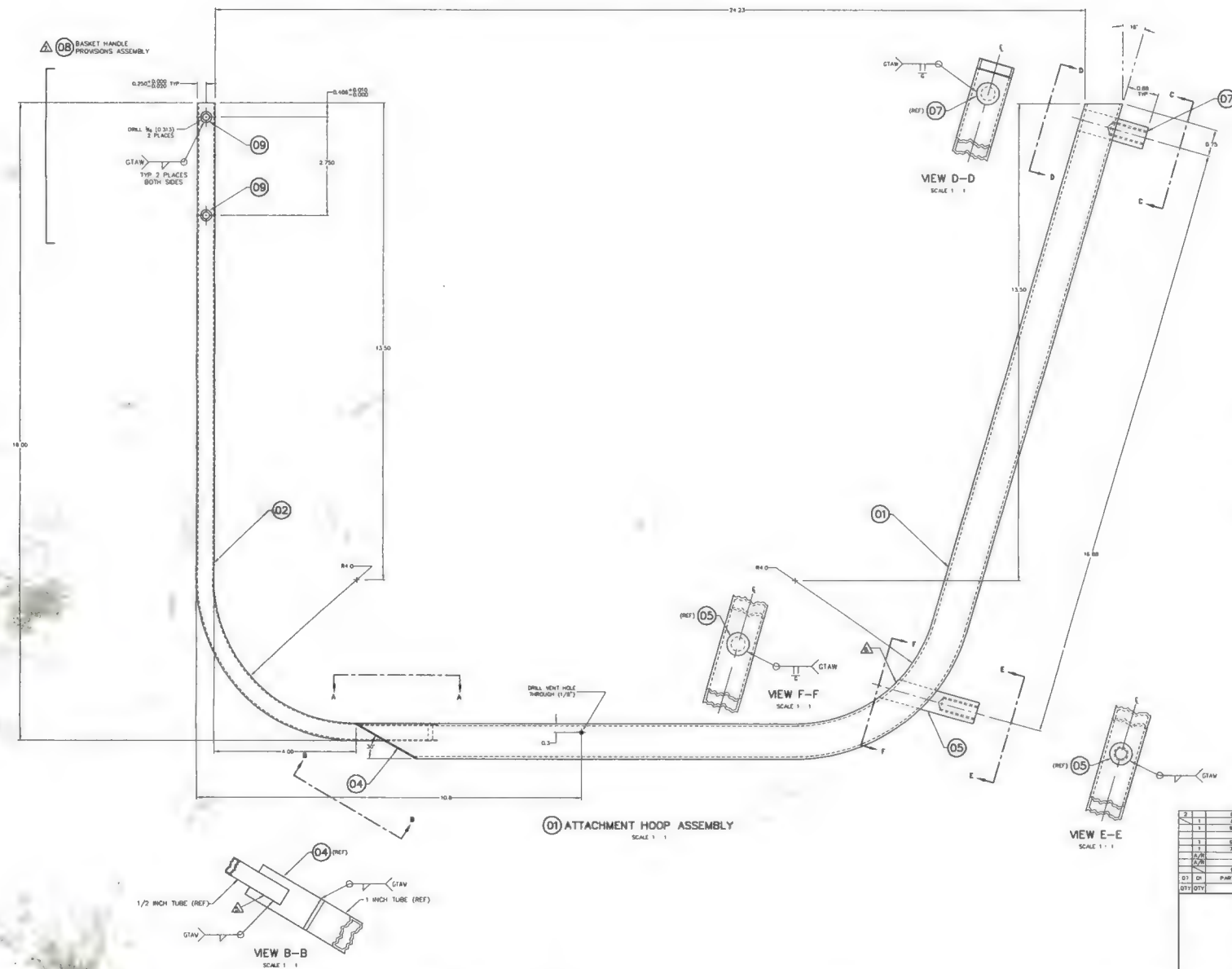
1 INCH TUBE (REF)

6149

VIEW A-A

SCALE 1:1

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INITIAL BLOOD UPDATED; NEW R/S UPDATED; 84262 HANDLE PROVISIONS ADDED	ILIC	11/28/72



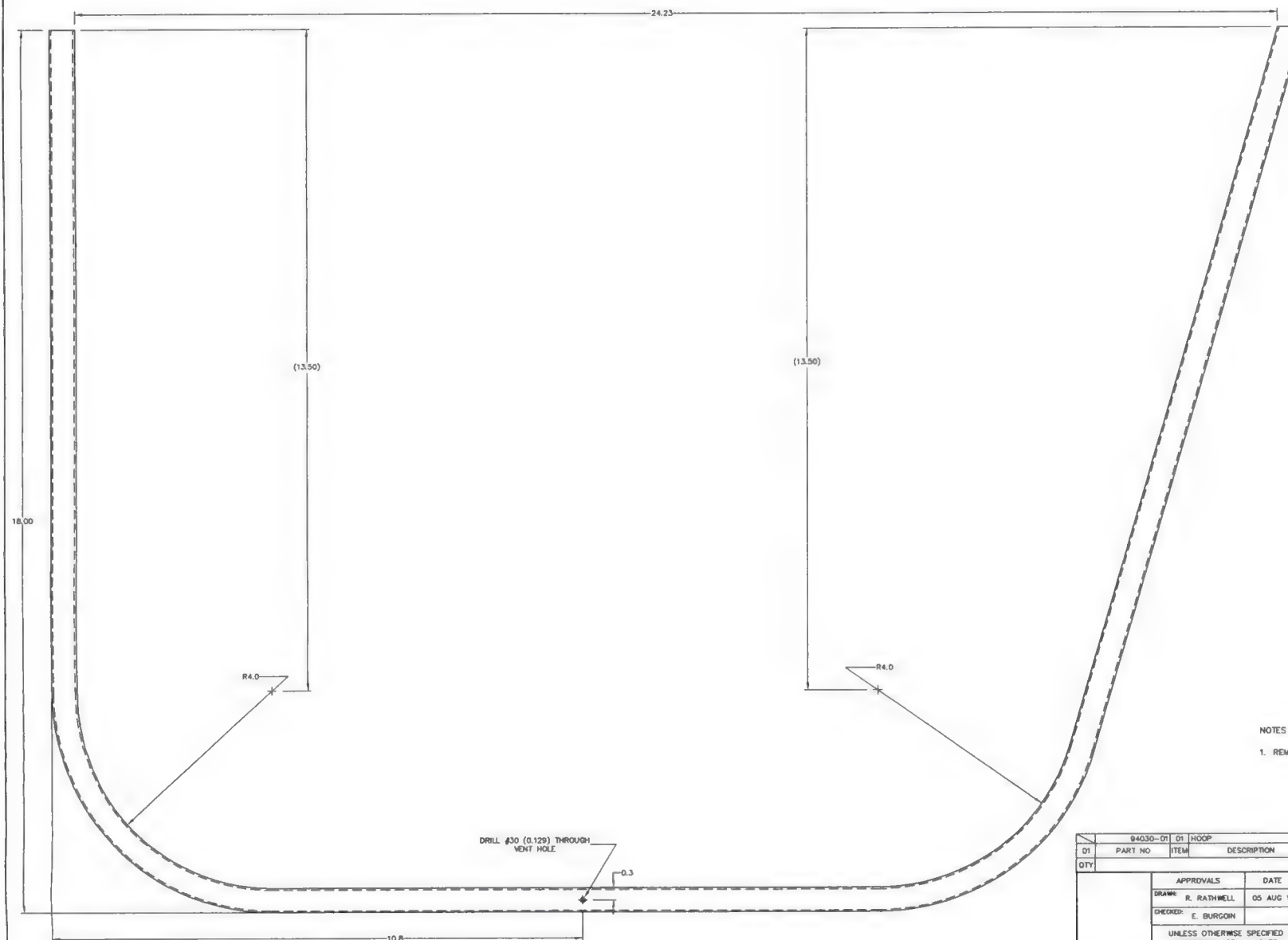
NOTES

1. REMOVE ALL BURRS AND SHARP BREAK EDGES.
2. (REMOVED)
3. BELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS2985C. WELDING JOINT SHALL CONFORM TO AWS ERTOS-2 OR EQUIVALENT
4. MILL SLOT INTO I/T TUBE AS SHOWN. CONTOR END OF 1/2" TUBE TO WAREAGE GAP BETWEEN 1/4" TUBE AND ITEM 172" TUBE.
5. ADJUST SLOT OF CAP (#2423-04) TO FIT AS REQUIRED.
6. CUT AWAY PORTION OF SLUG (#4023-06) FLUSH TO INSIDE SURFACE OF 1/2" TUBE AS SHOWN.
7. BASKET HANDLE PROVISIONS ARE INSTALLED IN ACCORDANCE WITH AERO DESIGN SPECIFICATION 16125. DIMENSIONS AND PARTS SHOWN ARE THE REFERENCE.

2	84272-02	02	BUSHING				
3	84272-02	02	BARREL MOUNTING PRODUCTIONS ASSEMBLY				
4	84023-04	04	FLYER				
5	84023-04	04	FLYER				
6	84023-04	04	FLYER				
7	84023-04	04	FLYER				
8	84023-04	04	FLYER				
9	84023-04	04	FLYER				
10	84023-04	04	FLYER				
11	84023-04	04	FLYER				
12	84023-04	04	FLYER				
13	84023-04	04	FLYER				
14	84023-04	04	FLYER				
15	84023-04	04	FLYER				
16	84023-04	04	FLYER				
17	84023-04	04	FLYER				
18	84023-04	04	FLYER				
19	84023-04	04	FLYER				
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24	84023-04	04	FLYER				
25	84023-04	04	FLYER				
26	84023-04	04	FLYER				
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28	84023-04	04	FLYER				
29	84023-04	04	FLYER				
30	84023-04	04	FLYER				
31	84023-04	04	FLYER				
32	84023-04	04	FLYER				
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60	84023-04	04	FLYER				
61	84023-04	04	FLYER				
62	84023-04	04	FLYER				
63	84023-04	04	FLYER				

2017-133

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; DRAWING REFORMATTED TO A1	BJC	11/07/2014



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

01 HOOP
SCALE 1 : 1

B4030-01		01 HOOP		4130 STEEL COND. H		MIL-T-8738		0.5 X 0.035 SOR TUBE	
D1	PART NO	ITEM	DESCRIPTION	MATERIAL		MATERIAL SPEC		STOCK SIZE	
LIST OF MATERIALS									
APPROVALS				DATE		 <div>AERO DESIGN LTD. 8008A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604 683.8976 www.aerodesign.ca</div>			
DRAWN: R. RATHWELL				05 AUG 11					
CHECKED: E. BURCOH									
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:									
DECIMALS				ANGLES		EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET HOOP			
X.XXX ±0.010				±1/2°					
X.XX ±0.03									
X.X ±0.1									
				SCALE 1 : 1		DWG. NO.		REV.	
				SHEET 1 OF 1		A1 94030		1	

Work Order: 2017-133Date Opened: Aug 1, 2017

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Hoops Fabrication

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>12</u>		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>17038</u>
	<u>10</u>		94023-01	Hoop - attachment		
Step 1				<i>1/2 Hoop Fabrication - 1/2" hoop</i>		
	<u>10</u>		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>17038</u>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>1/2 Hoop Fabrication - 1" hoop</i>		
	<u>10</u>		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	<u>17038</u>
Step 4				<i>Machining</i>	<i>None</i>	
Step 5				<i>Joint Preparation</i>	<i>None</i>	
				<i>Welding</i>		
Step 6	<u>10</u>		94023-05	Stud	1018 Mild Steel, 5/8" Dia.	<u>2015-108</u>
	<u>10</u>		94023-07	Stud	1018 Mild Steel, 5/8" Dia.	<u>2015-108</u>
Step 7	<u>20</u>	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	<u>2016-134</u>
Step 8	<u>10</u>		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	<u>15035</u>
	A/R		--	Welding Rod	ER70S-2	<u>16078</u>
Step 9				<i>Finishing and Inspection</i>	<i>None</i>	

2017-133

CARGO BASKET BODY FABRICATION - COMMON

AS350 Ski. (~~S~~)
49C.

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

AS350 ski (5) (4) DRH

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2017-133

Date Open: Aug 1 2017

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

AD 73-04 05 N/A

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD 73-04 05 N/A

3. Inspection

- a. Rim for complete welds

AD 73-04 05 N/A

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

AD 73-04 05 N/A

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

6. Inspection

- a. Frame assembly for complete welds.

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

AD 73-04 05
AD 73-04 05
AD 73-04 05
AD 73-04 05
N/A

Entered in Error
AD 73-04 05
N/A

Entered in error ok
AD 73-04 05
N/A

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete

(initial or SCA #)

8. Weld mesh to frame assembly per drawing.

- a. Ensure lug locating jig is in place prior to welding.
- b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
- c. Bend and trim cells bent in to fit mesh as required and weld in position.
- d. Grind high spots off body mesh welds on ends before welding end mesh.
- e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
- f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

M/A

e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

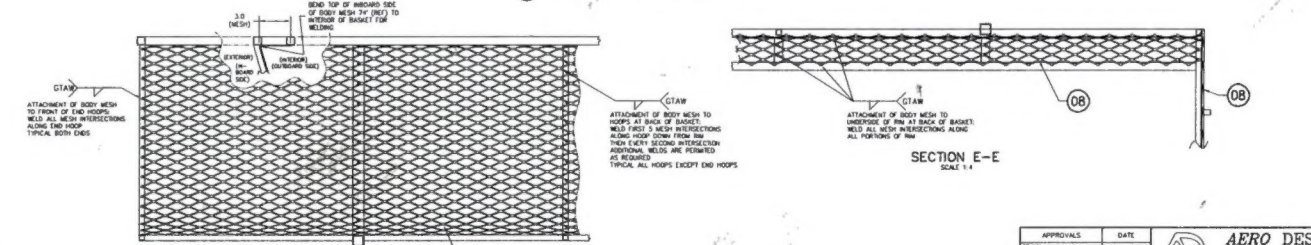
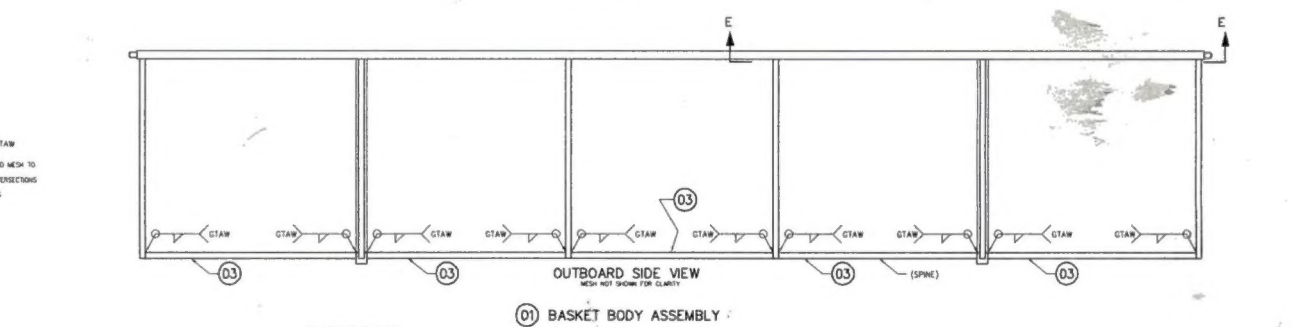
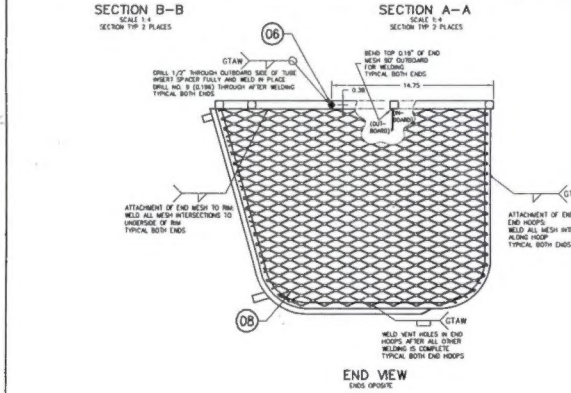
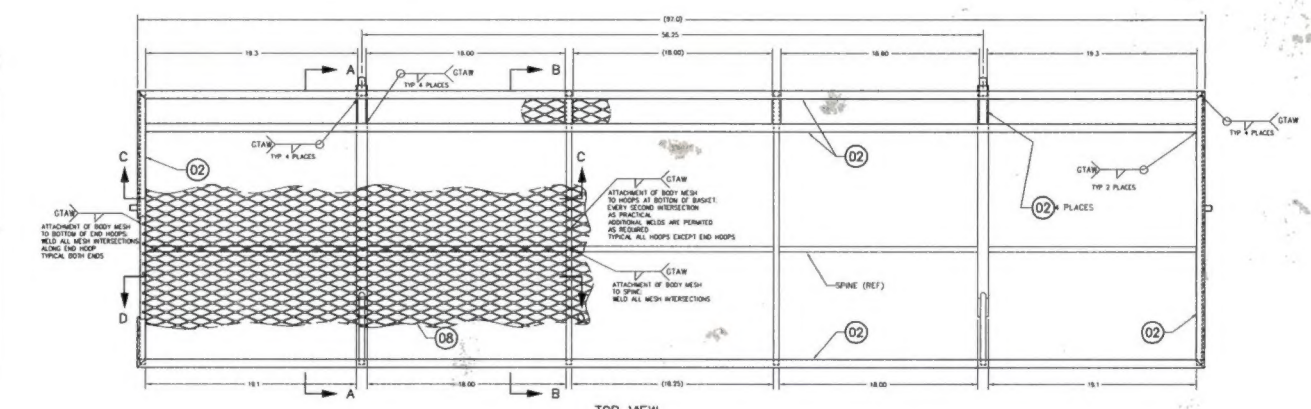
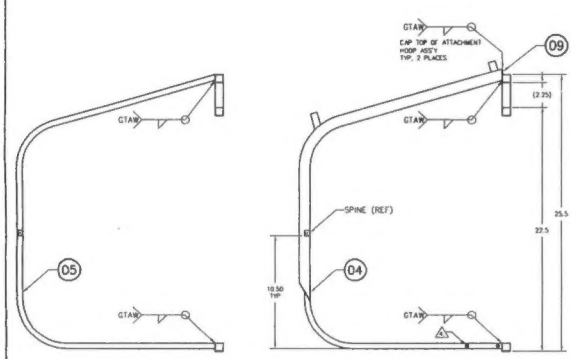
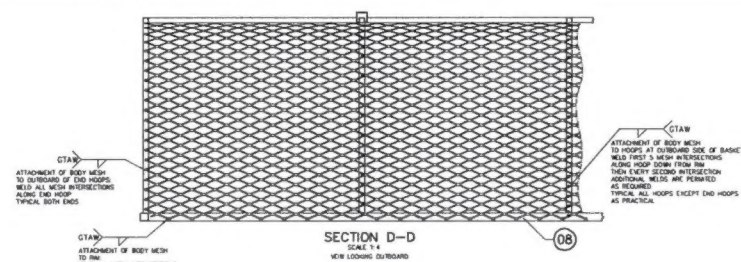
- Parts are to be powder coated white in accordance with commercial practices.
- Record powder coating PO.
- Inspect powder coating on receiving.
- Tag basket body assembly and place into stock in preparation for assembly.

<u>AD</u> 73-04 02	<u>CMB</u>	<u>CMB</u>	<u>CMB</u>	<u>N/A</u>
	AD 73-04 02	AD 73-04 02	AD 73-04 02	

2017-133

X (5) 4 DRN

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	WELD BLOCK UPDATED: WELDING ROD UPDATED: REFERENCED DATA ADDED	BY	12/20/2017
2	NEW HOOPS UPDATED: WELDS BOWING TABLES INCREASED		



- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. PRIOR TO WELDING, DRILL AND DEBURR VENT HOLES IN ASSEMBLY FOR WELDING OF MESH CASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
 3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AINS SPEC.
 4. 4130 AND 1018 STEEL WELDING ROD SHALL CONFORM TO ASTM A531 OR EQUIVALENT.
 5. STAINLESS AND 4130 STEEL WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
 6. INSTALL ITEM 7 (BASKET HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING B420 BEFORE WELDING HOOPS TO INBOARD.
 7. FINISH THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY.

QTY	PART NO.	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
1	01	BASKET BODY ASSEMBLY	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE
1	02	SPACER	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE
1	03	ATTACHMENT HOOP	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE
1	04	END HOOP	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE
1	05	END HOOP	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE
1	06	END HOOP	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE
1	07	END HOOP	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE
1	08	END HOOP	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE
1	09	END HOOP	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE
1	10	END HOOP	4130 STEEL CONG. N.	MIL-C-8738	1/2" X 6.035 SQ. TUBE

APPROVALS	DATE	REVISION	DATE
DESIGNED BY: R. BATHWELL	05 AUG 11	REVISED BY: E. BURTON	05 AUG 11
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DIMENSIONS IN INCHES X REF. ±0.010 X REF. ±0.013 X REF. ±0.1			
AERO DESIGN LTD. 8888 KALAPALKA ROAD POWELL RIVER, BC, CANADA V8A 0G3 TEL: 250.486.0378 www.aerodesign.ca			
EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY (EXTRA LARGE)			
SCALE 1:4		SHEET 1 OF 1	
A0		94011 1	

Work Order: 2017-133Date Opened: Aug 12017

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	540	94011	94011-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	17055
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	17055
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	17055
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	17055
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033/17037
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	17038 / (4) 2017-83
	. 2		94023-01	Hoop - attachment		See attached PDS
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	17038
Step 4.g.		70406	70406-01	<i>Option: Front End Cutout</i>		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	N/A
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	N/A
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033/17037
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	16009
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	17025

Work Order: 2017-133Date Opened: Aug 1, 2017Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				Weld Mesh		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	16078
Step 9				Weld Basket Components		
	2		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	2015-84
	A/R		--	Welding Rod	ER308L TIG Rod	17066
Step 10				Clean Up	None	
Step 11				Inspection - Final Assembly	None	
Step 12				Powder Coating		17085 17086 (1) (3)